

Date: Tuesday, 16/09/2008 1:21:57 PM
User: Julie Lecocq

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 42024-2
Estimate Number : 11174
P.O. Number :
This Issue : 16/09/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL / MED FAB
Previous Run : 39870
Written By :
Checked & Approved By : JLD 08.9.16
Comment : Est. B 05.05.25 Added Step 11 KJ/JLM
Est. C 06.05.09 Ecn 798 EC
Est Rev:D Now on Waterjet 06-06-16 JLM
Est rev E rev C dwg 07.09.28 EC verified by: DD

Drawing Name : REPLACEMENT WINDOW ASSEMBLY
Part Number : D3290041
Drawing Number : D3290 REV C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 30/09/2008 Qty: 10 Um: Each

6

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 3.9375 sf(s)/Unit Total : 39.3750 sf(s)

M6061T6S040

Batch: 107461 AB 8-9-17

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3290 (use prog. for D3290-1)

Dwg Rev: C AB 8-9-17

Prog Rev: C

2-Deburr if necessary AB 8-9-17

10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/09/18 10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

35975 39873

Date: Tuesday, 16/09/2008 1:21:57 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 42024

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



11108523

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:30AM

JH 08-09-18 (A10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/09/18

8.0

D2126

Seal



Comment: Qty.: 6.5000 f(s)/Unit Total: 65.0000 f(s)

Locking Seal

Pick:

Qty	Part Number	Description	Batch
1	D2126-0780	Locking Seal	

B35251

Comp
want
take it

B35251 → SAN 08/10/10 (4)

08/09/18 (24)

9.0

D32903

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Window

Pick:

Qty	Part Number	Description	Batch
1	D3290-3	Window	

3 9873 x1

35975 x3

B42120 → SAN 08/10/10 (6)

08/09/18 (24)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3290

Clean D3290-041 and place in plastic wrap

SAN 08/10/10 (6)
SAN 08/09/18 (24)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/10 (26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 16/09/2008 1:21:57 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REPLACEMENT WINDOW ASSEMBLY

Job Number: 42024

Part Number: D3290041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 218

AS 08/10/10 (X6)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/10 JF

Job Completion



U 08.10.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42024
Description: Window Frame		Part Number: D3290-1
Inspection Dwg: D3290	Rev: C	Page 1 of 1

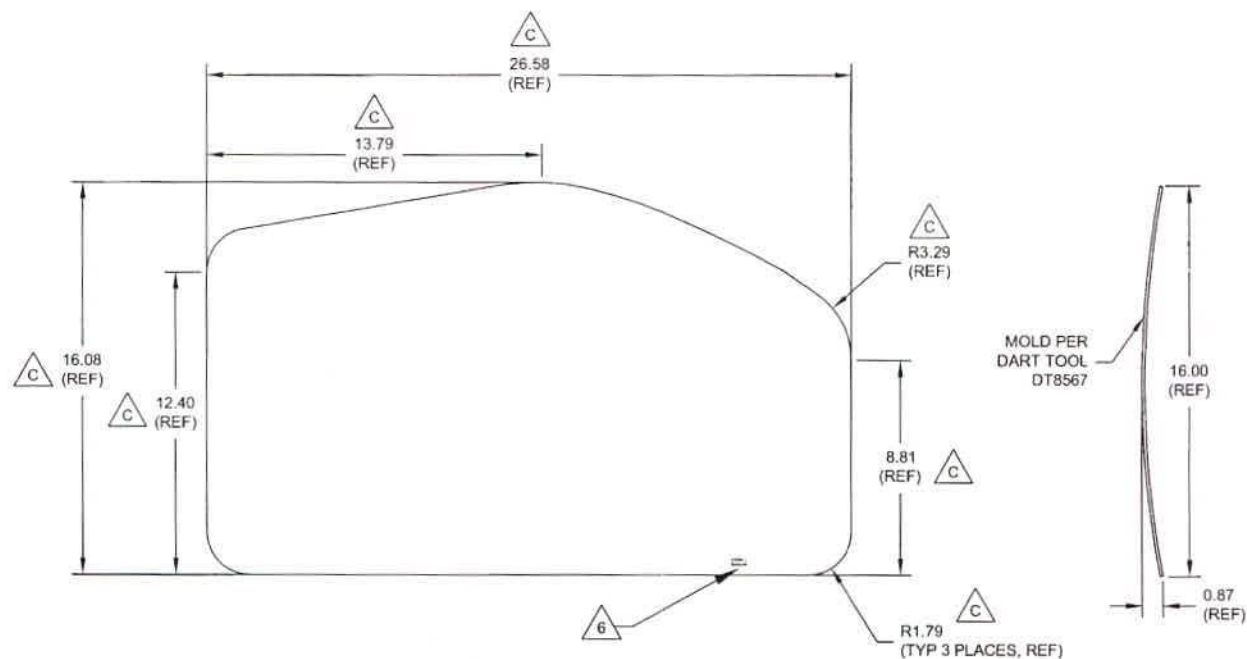
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	x			
14.00	+/-0.030	14.00	x			
Ø0.171	+0.005/-0.001	0.175	x			
1.50	+/-0.030	1.506	x			
1.11	+/-0.030	1.115	x			
10.10	+/-0.030	10.10	x			
18.50	+/-0.030	18.50	x			
0.040	+/-0.010	0.039	*			
R3.00	+/-0.030	3.00	x			
R4.50	+/-0.030	4.50	x			
Ø0.257	+0.006/-0.001	0.263	x			
13.61	+/-0.030	13.61	x			

Measured by: HB	Audited by: S	Prototype Approval:	N/A
Date: 8-9-17	Date: 08/09/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	EE



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

RELEASED
07.09.22

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3290 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42024